



US009056934B2

(12) **United States Patent**
Mentak

(10) **Patent No.:** **US 9,056,934 B2**
(45) **Date of Patent:** **Jun. 16, 2015**

- (54) **NANOHYBRID POLYMERS FOR OPTHALMIC APPLICATIONS**
- (71) Applicant: **Key Medical Technologies, Inc.**, San Ramon, CA (US)
- (72) Inventor: **Khalid Mentak**, San Ramon, CA (US)
- (73) Assignee: **KEY MEDICAL TECHNOLOGIES, INC.**, San Ramon, CA (US)
- (*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.
- (21) Appl. No.: **13/848,821**
- (22) Filed: **Mar. 22, 2013**
- (65) **Prior Publication Data**
US 2013/0231449 A1 Sep. 5, 2013

Related U.S. Application Data

- (60) Continuation of application No. 13/272,971, filed on Oct. 13, 2011, now Pat. No. 8,420,753, which is a continuation of application No. 12/823,572, filed on Jun. 25, 2010, now Pat. No. 8,048,972, which is a continuation of application No. 11/942,527, filed on Nov. 19, 2007, now Pat. No. 7,745,555, which is a division of application No. 11/005,820, filed on Dec. 7, 2004, now Pat. No. 7,446,157.

- (51) **Int. Cl.**
C08F 226/12 (2006.01)
C08F 220/26 (2006.01)
C08F 212/32 (2006.01)
C08F 222/10 (2006.01)
- (52) **U.S. Cl.**
CPC **C08F 226/12** (2013.01); **C08F 212/32** (2013.01); **C08F 220/26** (2013.01); **C08F 222/1006** (2013.01)
- (58) **Field of Classification Search**
USPC 526/88, 259, 263
See application file for complete search history.

- (56) **References Cited**

U.S. PATENT DOCUMENTS

2,461,460 A	8/1949	Winnek
2,989,529 A	6/1961	Schuler
4,304,895 A	12/1981	Loshaek
4,312,725 A	1/1982	Loshaek et al.
4,390,676 A	6/1983	Loshaek
4,528,311 A	7/1985	Beard
4,595,548 A	6/1986	St. Clair et al.
4,603,061 A	7/1986	St. Clair et al.
4,611,892 A	9/1986	Kawashima
4,636,212 A	1/1987	Posin
4,665,123 A	5/1987	Goldenbeg
4,719,248 A	1/1988	Bambury
4,731,079 A	3/1988	Stoy
4,834,750 A	5/1989	Gupta
4,851,521 A	7/1989	Della Valle et al.
4,863,539 A	9/1989	Lee
4,872,877 A	10/1989	Tiffany

5,080,688 A	1/1992	Cohen
5,093,408 A	3/1992	Jung
5,098,445 A	3/1992	Hung
5,132,384 A	7/1992	Matsuda
5,194,544 A	3/1993	Goldberg
5,217,491 A	6/1993	Vanderbilt
5,290,892 A	3/1994	Namdaran
5,326,506 A	7/1994	Vanderbilt
5,331,073 A	7/1994	Weinschenk
5,338,826 A	8/1994	St. Clair et al.
5,359,021 A	10/1994	Weinschenk
5,374,663 A	12/1994	Daicho
5,403,901 A	4/1995	Namdaran
5,428,102 A	6/1995	St. Clair et al.
5,433,746 A	7/1995	Namdaran
5,470,932 A	11/1995	Jinkderson
5,480,950 A	1/1996	Wang
5,496,368 A	3/1996	Wiese
5,528,322 A	6/1996	Jinkerson
5,543,504 A	8/1996	Jinkerson
5,556,931 A	9/1996	Imura
5,603,774 A	2/1997	LeBoeuf
5,608,471 A	3/1997	Miller
5,639,850 A	6/1997	Bryant
5,654,350 A	8/1997	Nunez
5,662,707 A	9/1997	Jinkerson
5,674,960 A	10/1997	Namdaran
5,693,095 A	12/1997	Freeman
5,728,157 A	3/1998	Prescott

(Continued)

FOREIGN PATENT DOCUMENTS

EP	0485197	10/1996
EP	0826158	9/1999

(Continued)

OTHER PUBLICATIONS

JPO Office Action mailed on Dec. 27, 2010 for Japanese Patent App. No. 2007-545625.

English translation of examiner's comment in JPO Office Action mailed on Dec. 27, 2010 for Japanese Patent App. No. 2007-545625.

Extended European Search Report mailed Jan. 19, 2011 for European Patent App. No. 05853372.0.

English translation of examiner's comment in JPO Office Action mailed on Apr. 25, 2012 for Japanese Patent App. No. 2007-545625.

Acrylens™, "A technical evaluation of foldable intraocular lenses," distributed by Ioptex Research, Inc. (1990).

Acrysof® Natural single piece IOL, Product Monograph, 2004 by Alcon Laboratories, Inc.

(Continued)

Primary Examiner — Ling Choi

Assistant Examiner — Chun-Cheng Wang

(74) *Attorney, Agent, or Firm* — Whyte Hirschboeck Dudek S.C.

(57) ABSTRACT

The present invention relates to novel materials particularly useful for ophthalmic applications and methods for making and using the same. More particularly, the present invention relates to relatively soft, optically transparent, foldable, high refractive index materials particularly suited for use in the production of intraocular lenses, contact lenses, and other ocular implants and to methods for manufacturing and using the same.

5 Claims, No Drawings

(56)

References Cited

U.S. PATENT DOCUMENTS

5,741,883	A	4/1998	Bryant	
5,776,191	A	7/1998	Mazzocco	
5,789,463	A	8/1998	Odagiri	
5,814,680	A	9/1998	Imafuku	
5,821,306	A	10/1998	Hodd	
5,842,971	A	12/1998	Yoon	
5,849,841	A	12/1998	Muhlebach	
5,855,825	A	1/1999	Ito	
5,856,370	A	1/1999	Chmelir	
5,861,031	A	1/1999	Namdaran	
5,891,931	A	4/1999	LeBoeuf	
5,922,550	A	7/1999	Everhart	
5,922,821	A	7/1999	LeBoeuf	
5,945,498	A	8/1999	Hopken	
6,030,078	A	2/2000	Ocampo	
6,048,951	A	4/2000	Wunsch et al.	
6,113,814	A	9/2000	Gemert et al.	
6,149,692	A	11/2000	Lally	
6,150,479	A	11/2000	Klemarczyk	
6,201,061	B1	3/2001	Amagai	
6,201,089	B1	3/2001	Carter	
6,218,463	B1	4/2001	Molock	
6,265,465	B1	7/2001	Benz	
6,271,281	B1	8/2001	Liao	
6,281,319	B1	8/2001	Mentak	
6,326,448	B1*	12/2001	Ojio et al.	526/259
6,329,485	B1	12/2001	Vanderbilt	
6,342,570	B1	1/2002	Bothe et al.	
6,673,886	B2	1/2004	Vanderbilt	
6,673,888	B2	1/2004	Kosaka	
7,399,811	B2	7/2008	Mentak	
7,446,157	B2	11/2008	Mentak	
7,745,555	B2	6/2010	Mentak	
2001/0049400	A1	12/2001	Alli	
2002/0037984	A1*	3/2002	Vanderbilt	526/227
2002/0042483	A1	4/2002	Vanderbilt	
2002/0042484	A1	4/2002	Vanderbilt	
2002/0049290	A1	4/2002	Vanderbilt	
2002/0064513	A1	5/2002	Maitra	
2002/0156047	A1	10/2002	Zhao	
2003/0099694	A1	5/2003	Unger	
2004/0063200	A1	4/2004	Chaikof et al.	
2004/0147501	A1	7/2004	Dolmans	
2004/0156880	A1	8/2004	Ravi	
2005/0254003	A1	11/2005	Jani et al.	
2007/0159594	A9	7/2007	Jani et al.	
2012/0035337	A1	2/2012	Mentak et al.	
2013/0231449	A1	9/2013	Mentak et al.	

FOREIGN PATENT DOCUMENTS

EP	0820601	12/1999
EP	1026182	A1 8/2000

EP	1431350	6/2004
GB	2171106	8/1986
GB	2381482	5/2003
JP	2000119420	4/2000
JP	A-2002-511598	4/2002
JP	2005048088	2/2005
JP	2005089654	4/2005
JP	2005532094	10/2005
WO	9325593	12/1993
WO	9505164	2/1995
WO	9522991	8/1995
WO	9618498	6/1996
WO	9631791	10/1996
WO	9636890	11/1996
WO	9640303	12/1996
WO	9724382	7/1997
WO	9853920	12/1998
WO	9901034	1/1999
WO	9906321	2/1999
WO	0014591	3/2000
WO	0034804	6/2000
WO	0118078	3/2001
WO	0118079	3/2001
WO	0125301	4/2001
WO	0209647	2/2002
WO	03000777	1/2003
WO	2004044012	5/2004
WO	2005001019	1/2005

OTHER PUBLICATIONS

Koch, D.D., "Alcon AcrySof Acrylic intraocular lenses," Slack Inc. (1993) 8:161-177.

Luo et al., "Modification of natural polymers: Hyaluronic acid," Methods of Tissue Engineering (Atala and Lanza eds.) (2002) Academic Press, Orlando, Florida 539-553.

Packard et al., "Poly-HEMA as a material for intraocular lens implantation: a preliminary report," J. Ophthalmol. (1981) 65:585-587.

Prouty et al., "Fibroblast-dependent induction of a murine skin lesion with similarity to human common blue nevus," Am. J. Pathol. (1996) 148(6):L 1871-1885.

Tomihata et al., "Cross-linking of hyaluronic acid and water-soluble carbodiimide," J. Biomed. Mater. Res. (1997) 37(2):243-251.

Wang, "Synthesis and properties of benzotriazoles as UV absorbers," J. East China Univ. of Sci. Tech. (1999) 25(2):167-169, 173.

Website Eye Care Products pp. (3) regarding Silicone SQ IOL Model 301 obtained from www.medennium.com/prod_contaract.htm, on May 2, 2005.

Website Product Description of Sensar®, obtained from www.amoinc.com/site/products/consumers on May 2, 2005.

<http://www.alconlabs.com>, "All about cataracts, the AcrySof IOL story," (2003) 1-3.

Japanese office action for application No. 229689 dated Nov. 4, 2014 with the English translation, 9 pages.

* cited by examiner

NANOHYBRID POLYMERS FOR OPHTHALMIC APPLICATIONS

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a continuation of application Ser. No. 13/272,971 filed on Oct. 13, 2011 now U.S. Pat. No. 8,420,753, which is a continuation application of application Ser. No. 12/823,572 filed on Jun. 25, 2010 now U.S. Pat. No. 8,048,972, which is a continuation of U.S. patent application Ser. No. 11/942,527, filed Nov. 19, 2007, now U.S. Pat. No. 7,745,555, which is a divisional of U.S. patent application Ser. No. 11/005,820, filed Dec. 7, 2004, now U.S. Pat. No. 7,446,157, which is incorporated herein by reference. An additional sibling, Application Ser. No. 11/942,557, filed Nov. 19, 2007, now U.S. Pat. No. 7,399,811, which is also a divisional of parent patent application Ser. No. 11/005,820, is also incorporated by reference herein.

FIELD OF THE INVENTION

The present invention relates to novel materials particularly useful for ophthalmic applications and methods for making and using the same. More particularly, the present invention relates to relatively soft, optically transparent, foldable, high refractive index materials particularly suited for use in the production of intraocular lenses, contact lenses, and other ocular implants and to methods for manufacturing and using the same.

BACKGROUND OF THE INVENTION

Since the 1940's optical devices in the form of intraocular lenses (IOLs) have been utilized as replacements for diseased or damaged natural ocular lenses. In most cases, an intraocular lens is implanted within an eye at the time of surgically removing the diseased or damaged natural lens, such as for example, in the case of cataracts. For decades, the preferred material for fabricating such intraocular lenses was poly(methyl methacrylate), which is a rigid, glassy polymer.

Softer, more flexible IOLs have gained in popularity in recent years due to their ability to be compressed, folded, rolled or otherwise deformed. Such softer IOLs may be deformed prior to insertion thereof through an incision in the cornea of an eye. Following insertion of the IOL in an eye, the IOL returns to its original, pre-folded shape due to the memory characteristics of the soft material. Softer, more flexible IOLs as just described may be implanted into an eye through an incision that is less than 4.0 mm i.e., much smaller than the 5.5 to 8.0 mm necessary to implant more rigid IOLs. A larger incision is necessary for more rigid IOLs because the lens must be inserted through an incision in the cornea slightly larger than the diameter of the inflexible IOL optic portion. Accordingly, more rigid IOLs have become less popular in the market since larger incisions have occasionally been found to be associated with an increased incidence of postoperative complications, such as induced astigmatism.

With recent advances in small-incision cataract surgery, increased emphasis has been placed on developing soft, foldable polymer materials suitable for use in artificial IOLs. In general, these materials fall into one of three categories: hydrogels, silicones and low glass transition temperature acrylics.

In general, high water content hydrogel materials have relatively low refractive indexes, making them less desirable than other materials with respect to minimal incision size.

Low refractive index materials require a thicker TOL optic portion to achieve a given refractive power. Silicone materials may have a higher refractive index than high-water content hydrogels, but tend to unfold too rapidly after being placed in the eye in a folded position. A too rapid unfolding of a folded lens can potentially damage the corneal endothelium and/or rupture the natural lens capsule and associated zonules. Low glass transition temperature acrylic materials are desirable because they typically have a high refractive index and unfold more slowly and more controllably than silicone materials when inserted into e.g., the lens capsule. Unfortunately, low glass transition temperature acrylic materials, which contain little or no water initially, may absorb pockets of water, in vivo, causing light reflections or "glistenings". Furthermore, it is difficult to achieve ideal folding and unfolding characteristics due to the temperature sensitivity of the acrylic polymers.

U.S. Pat. No. 5,480,950 issued Jan. 2, 1996 teaches of high refractive index hydrogel materials having a hydrated equilibrium water content of at least 57% for use in the manufacture of IOLs. The high refractive index hydrogel materials are cross-linked from mixtures of N-vinylpyrrolidone, 4-vinylpyrimidine and a vinyl pyridine having equilibrium water contents up to 90% and refractive indexes of 1.560 to 1.594 in the dry state. The IOLs as described are not implanted in a hydrated state. Rather, the IOLs are implanted in a dry, folded and elongated state and hydrated in situ. The refractive indexes in the hydrated state as used in the eye are not provided.

U.S. Patent Application Publication 2002/0049290 relates to high refractive index (RI) ophthalmic hydrogel materials.

U.S. Pat. No. 5,693,095 issued Dec. 2, 1997 teaches of high refractive index, low water content IOL materials. The materials taught in this particular patent are acrylic materials having an elongation of at least 150%. IOLs manufactured from a material having such elongation characteristics will not crack, tear or split when folded. However, such low water content acrylic materials have been found to be less biocompatible than other materials when manufactured into and used as IOL devices.

In the past decade, hydrophobic polymers have been used in IOL manufacturing with some success. The ophthalmic community has accepted this type of polymer as having good physical properties and acceptable biocompatibility in ocular environments. However, current IOLs made from conventional hydrophobic polymers sometimes suffer from poor optical stability in ocular fluids (e.g. glistenings, optical artifacts) and low refractive indices. The formation of unwanted particles and deposits in the bulk of hydrophobic polymers is attributed to uncontrolled water sorption and subsequent phase separation. Conventional homopolymers currently used to produce copolymers with high RIs (>1.51) absorb varying amounts of water in a sporadic fashion, creating phase separation, haze, and glistenings.

Currently, there are no foldable, high RI IOL polymers that resist the formation of glistenings and deposits.

SUMMARY OF THE INVENTION

The present invention is a new family of high RI polymers particularly suitable for, but not limited to, foldable IOL applications. Materials of this invention are optically stable in ocular fluids and resist the formation of unwanted optical artifacts. The unusual properties of the copolymers of this invention are achieved by creating nanoclusters of a generally hydrophilic polymer within a very hydrophobic polymer matrix. Water sorption is minimized and limited to the nano-

clusters. In addition, the limited amount of water that is absorbed is well distributed and well dispersed within the matrix, preventing macrophase separation noted in prior art compositions. The approximate nanosize diameter of the clusters is in the range of 1.0 nm or less. Generally speaking the sizes of clusters operable in this invention will be of a diameter small enough so as to have little or interaction between visible light and the polymer network. The result is an optically clear material with stable optical properties.

This invention relates to novel copolymers for intraocular lenses ("IOL"), contact lens, and other ophthalmic and optical applications. IOLs made from the materials of this invention have a very high refractive index, and may be machined at around room temperature. IOLs of this invention may be folded and used to replace a defective natural lens of the eye by insertion through a small incision without the need for further processing or hydration. A particular advantage of the materials of this invention is their unusual hybrid character that prevents uncontrolled water sorption.

Foldable ophthalmic lens materials having controllable, uniform, relatively high water content and unexpectedly high refractive indices particularly suited for use as intraocular lenses (IOLs), or other ophthalmic devices such as but not limited to contact lenses, keratoprotheses and corneal rings or inlays, are the primary loci of the present invention.

This invention relates to copolymer compositions comprising limited amounts of a monomer having, for example, a carbazole and/or naphthyl moiety, carbazole, naphthalene, or a naphthyl group and a hydrophobic monomer. Carbazole and or naphthyl moiety monomers are added to the comonomer to increase the refractive index of the comonomer and increase the ability of the copolymer material to block blue light (wavelength up to 475 nm). A monomer having a surface tension generally in the range of 50 dyn/cm or less is used to create a very hydrophobic matrix. A hydrophilic polymer is added to create nanoclusters (in a process described below) for controlled water sorption.

Accordingly, it is an object of the present invention to provide a biocompatible IOL material having a high refractive index.

Another object of the present invention is to provide an IOL material having a high refractive index and controlled water sorption;

Still another object of the present invention is to provide an IOL material that is relatively simple to manufacture.

These and other objectives and advantages of the present invention, some of which are specifically described and others that are not, will become apparent from the detailed description and claims that follow.

DETAILED DESCRIPTION OF THE INVENTION

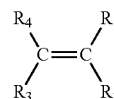
Materials of the present invention with high refractive indexes are desirable to allow manufacturers to manufacture thinner IOLs. A thin IOL or thin IOL optic is critical in enabling a surgeon to minimize incision size. Keeping the surgical incision size to a minimum reduces intraoperative trauma and postoperative complications. A thin IOL is also critical for accommodating certain anatomical locations in the eye such as the anterior chamber and the ciliary sulcus. IOLs may be placed in the anterior chamber for increasing visual acuity in both aphakic and phakic eyes and placed in the ciliary sulcus for increasing visual acuity in phakic eyes.

The preferred materials of the present invention have the flexibility required to allow the same to be folded or deformed so that IOLs made therefrom may be introduced into an eye through the smallest possible incision.

The novel materials of the present invention are copolymers, trimers, tetramers, etc., comprising three primary monomeric components: a high refractive index (RI) monomer, a hydrophobic monomer, and a hydrophilic monomer. A cross linker generally is included as is a UV absorber.

A high refractive index (RI) monomer of the present invention comprises a fused ring aromatic moiety coupled to an ethylenically unsaturated or vinylically unsaturated moiety. By the term "high refractive index monomer" it is intended that a polymer of the high RI monomer (i.e., a homopolymer of the monomer) has a refractive index of at least 1.50, preferably at least 1.53, and most preferably at least 1.56.

A vinylic or ethylene unsaturated moiety is, of course, well known to the art generally to mean a structure of the sort,



wherein:

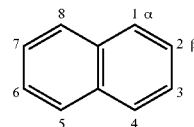
R_1 - R_4 are separately and independently, H, C, X, or R_c ;

R_c is any hydrocarbon moiety; and

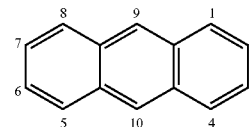
X is any heteratom, providing that at least one of R_1 - R_4 must be a fused ring aromatic structure or moiety as is discussed below. The fused ring aromatic structure can be, and often is, R_c .

"Fused ring aromatic" or polynuclear or polycyclic aromatic moieties are, of course well known. These moieties are characterized by the presence of at least two aromatic rings sharing a pair of carbon atoms. The best known examples of fused ring aromatic moieties are probably naphthalene, carbazole, anthracene, and phenanthrene. Their moieties, i.e., naphthyl, anthracyl, carbazole, and phenanthryl, are examples of preferred moieties of the high RI monomer. Further examples of such fused-ring aromatic molecules and hence their moieties include:

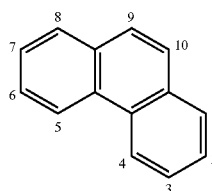
Fused Benzene Ring Compounds



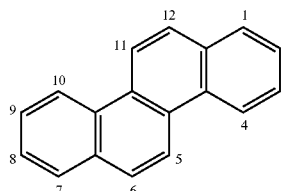
naphthalene
 $C_{10}H_8$
m.p. 81° C.



anthracene
 $C_{14}H_{10}$
m.p. 217° C.

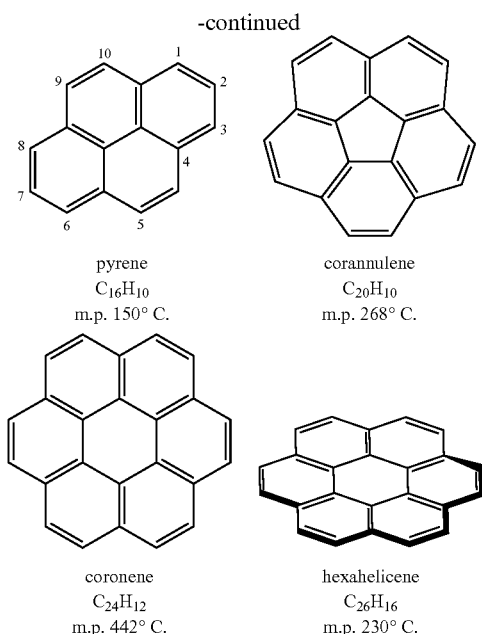


phenanthrene
 $C_{14}H_{10}$
m.p. 100° C.



chrysene
 $C_{18}H_{12}$
m.p. 253° C.

5



The above list is, of course, non-limiting. Further, the unsaturation moiety can be coupled to any one of the outer ring carbons of the above structures as would be readily apparent to one skilled in this art.

In a preferred practice, the high RI monomer comprises multimers including: a carbazole and or naphthyl moiety, the carbazole/naphthyl moiety monomer being present in the composition at a concentration of at least 15% and preferably up to about 25-45%.

The composition further includes a second monomer with a hydrophobic homopolymer, the hydrophobicity being defined as the homopolymer having a surface tension of about 50 dyn/cm or less, the second monomer being present in the copolymer, in an amount of at least about 20 weight percent, preferably about 50-60 weight percent.

The composition further includes at least about 10 weight percent of a hydrophilic monomer, preferably about 20-30 weight percent. The composition then includes a crosslinking monomer, the crosslinking monomer being present at a concentration in the range up to 10 weight percent, preferably of about 1 weight percent to about 8 weight percent.

Suitable hydrophilic monomers (i.e., monomers whose homopolymers are hydrophilic in accordance with this invention) include but are not limited to 2-hydroxy-ethylacrylate, 2-hydroxyethylmethacrylate, acrylamide, N-ornithine acrylamide, N-(2-hydroxypropyl)acrylamide, polyethyleneglycol acrylates, polyethyleneglycol methacrylates, N-vinyl pyrrolidone, N-phenylacrylamide, dimethylaminopropyl methacrylamide, acrylic acid, benzylmethacrylamide, 4-hydroxybutylmethacrylate, glycerol mono methacrylate, glycerol mono acrylate, 2-sulfoethylmethacrylate, phenoxyethyl acrylate, phenoxy ethyl methacrylate, 2-(2-ethoxyethoxy) ethyl acrylate, 2-(2-ethoxyethoxy)ethyl methacrylate, furfuryl acrylate, furfuryl methacrylate, and methylthioethylacrylamide.

Suitable hydrophobic monomers (i.e., monomers whose homopolymers are hydrophobic in accordance with this invention) include, but are not limited to, Lauryl methacrylate, lauryl acrylate, 2-ethylhexyl acrylate, 2-ethylhexyl methacrylate, n-decyl acrylate, n-decyl methacrylate, hexyl acrylate, hexyl methacrylate, stearyl acrylate, stearyl meth-

6

acrylate, isodecyl acrylate, isodecyl methacrylate, isobomyl acrylate, isobornyl methacrylate, vinyl laurate, vinyl stearate, 1-hexadecyl acrylate, 1-hexadecyl methacrylate, n-myristyl acrylate, n-myristyl methacrylate, n-dodecyl methacrylamide, butyl acrylate, n-butyl methacrylate, isooctyl acrylate, isotridecyl acrylate, isooctyl methacrylate, and isotridecyl methacrylate.

Suitable crosslinkers include, for example, but are not limited to, ethylene glycol dimethacrylate (EGDMA), diethylene glycol dimethacrylate, and triethylene glycol dimethacrylate wherein ethylene glycol dimethacrylate is preferred. Suitable initiators include, for example, but are not limited to, azobis (isobutyronitrile), 2,2'-azobis(2,4-dimethylvaleronitrile), 2,2'-azobis(methylbutyronitrile), 1,1'-azobis(cyanocyclohexane), di-t-butyl peroxide, dicumyl peroxide, t-butylcumyl peroxide, 2,5-dimethyl-2,5-bis(2-ethylhexanoyl peroxy)hexane, t-butyl peroxyneodecanote, t-butyl peroxy 2-ethylhexanoate, di(4-t-butyl cyclohexyl) peroxydicarbonate, t-butyl peroxy pivalate, decanoyl peroxide, lauroyl peroxide, benzoyl peroxide, 2,4-pentanedione peroxide, di(n-propyl) peroxydicarbonate, t-amyl peroxyneodecanoate and t-butyl peroxyacetate wherein 2,2'-azobis(isobutyronitrile) is preferred.

Suitable ultraviolet light absorbers include for example but are not limited to beta-(4-benzotriazolyl-3-hydroxyphenoxy) ethyl acrylate, 4-(2-acryloxyethoxy)-2-hydroxybenzophenone, 4-methacryloxy-2-hydroxybenzo-phenone, 2-(2'-methacryloxy-5'-methylphenyl)benzotriazole, 2-(2'-hydroxy-5'-methacryloxyethylphenyl)-2H-benzo-triazole, 2-[3'-tert-Butyl-2'-hydroxy-5'-(3"-methacryloyloxypropyl) phenyl]-5-chlorobenzotriazole, 2-(3'-tert-Butyl-5'-(3"-dimethylvinylisilylpropoxy)-2'-hydroxyphenyl)-5-methoxybenzotriazole, 2-(3'-Allyl-2'-hydroxy-5'-methylphenyl)benzotriazole, 2-[3'-tert-Butyl-2'-hydroxy-5'-(3"-methacryloyloxypropoxy)phenyl]-5-methoxybenzotriazole, and 2-[3'-tert-Butyl-2'-hydroxy-5'-(3"-methacryloyloxypropoxy)phenyl]-5-chlorobenzotriazole wherein beta-(4-benzotriazolyl-3-hydroxyphen-oxy)ethyl acrylate is the preferred ultraviolet light absorber.

A UV absorber optionally may be added to the copolymer compositions. A novel, preferred, UV/blue light absorber, i.e., vinyl anthracene, may be added to the copolymer compositions. Conventional U.V. absorbers such as a vinyl benzophenone or a vinyl benzotriazole also may be used.

A monomeric dye capable of copolymerizing with the hydrophobic and the hydrophilic monomers optionally may be added to the copolymer to attenuate specific wavelengths of light. Such dyes include but are not limited to those containing vinyl groups and are capable of absorbing violet, blue, red, and green light in the range of 400-700 nm.

Examples of such monomeric dyes include but are not limited to:

Disperse Red 13 acrylate,
Disperse Orange 3 acrylamide
Disperse Orange 3 methacrylamide
Disperse Red 1 methacrylate
Disperse Red 1 acrylate
Disperse Red 13 methacrylate
Disperse yellow 7 acrylate
Disperse yellow 7 methacrylate
Ethyl trans- α -cyano-3-indoleacrylate
[(S)-(-)-1-(4-Nitrophenyl)-2-pyrrolidinemethyl]acrylate

General Preparation Steps for Polymers of Examples 1-15

The comonomers listed below were mixed in a glass flask using a magnetic stir bar for at least 30 minutes, at room

temperature followed by sonication for the times indicated, and then stirring again for another 30 minutes. The combination of sonication and hydrophilic/hydrophobic repulsion forces allows the formation of nanoclusters. The size of the nanoclusters is theoretically controlled by the amount of energy provided during these steps. It was found that sonicating for about 30 minutes at a power setting of 100% on a Branson 5510 sonicator provides optically clear materials with adequate optical and physical properties. Sonicating time may vary between 1 minutes to 60 minutes depending on the formulation used. It has also been found that an optional second sonication step of at least about 10 minutes is sometimes needed to produce materials of the desired optical characteristics.

The resulting copolymers are rigid enough to be machined at around room temperature. A unique and surprising aspect of the above materials is that the refractive index of the copolymers is so high that ophthalmic lenses can be made thin enough to be folded without further processing or hydration.

Examples 1-15

	Mono- mer	Cocen- tration	RI	% EWC	Processing conditions
Ex. 1	VC	30	1.5690	1.5	20 minutes sonication twice
	LM	37			
	HEMA	30			
	EGDM	3			
Ex. 2	VC	30	1.5687	1.7	25 minutes sonication twice
	LM	37			
	HEA	30			
	EGDM	3			
Ex. 3	VC	30	1.5634	1.8	15 minutes sonication
	EHA	37			
	HEMA	30			
	EGDM	3			
Ex. 4	VC	30	1.5623	1.7	15 minutes sonication
	EHA	37			
	HEA	30			
	EGDM	3			
Ex. 5	VN	30	1.5541	1.7	10 minutes sonication
	EHA	37			
	HEMA	30			
	EGDM	3			
Ex. 6	VC	30	1.5512	1.6	10 minutes sonication
	EHA	37			
	HEA	30			
	EGDM	3			
Ex. 7	VC	25	1.5476	1.4	15 minutes sonication
	EHA	52			
	HEMA	20			
	EGDM	3			
Ex. 8	VC	25	1.5442	1.7	15 minutes sonication
	EHA	52			
	HEA	20			
	EGDM	3			
Ex. 9	VC	35	1.5623	1.7	10 minutes sonication
	EHA	47			
	HEMA	15			
	EGDM	3			
Ex. 10	VC	35	1.5601	1.1	15 minutes sonication twice
	EHA	47			
	HEMA	10			
	EGDM	3			
Preferred Formulations					
Ex. 11	VC	30	1.5590	1.2	30 minutes sonication
	EHA	42			
	HEMA	25			
	EGDM	3			

-continued

	Mono- mer	Cocen- tration	RI	% EWC	Processing conditions
Ex. 12	VC	27.5	1.5510	1.0	30 minutes sonication twice
	LM	44.0			
	HEA	25.5			
	EGDM	3			
Ex. 13	VC	27.0	1.5500	1.0	30 minutes sonication twice
	LM	42.0			
	HEA	24.0			
	EGDM	0.25			
	VA	0.45			
Ex. 14	VC	27.0	1.5511	1.0	30 minutes sonication twice
	LM	44.5			
	HEA	25.0			
	EGDM	2.5			
	DR1	0.02			
Ex. 15	VC	27.0	1.5505	1.0	30 minutes sonication twice
	LM	44.5			
	HEA	25.0			
	EGDM	2.5			
	DR1	0.01			

2.5% by weight of VA and 0.3% by weight of MEB was used in all copolymer compositions.

VC: vinyl carbazole

VN: 2-vinyl naphthalene

EHA: 2-ethylhexylacrylate

LM: Lauryl methacrylate

HEMA: Hydroxyethylmethacrylate

HEA: Hydroxyethylacrylate

EGDM: ethylene glycol dimethacrylate

VA: vinyl anthracene

MEB: 2-(2'-Methacryloxy-5'-methylphenyl)benzotriazole

DR 1: Disperse Red 1 Methacrylate

What is claimed is:

1. A composition comprising the polymerization product of a mixture of: a high refractive index monomer comprising a carbazole or naphthyl moiety, carbazole, naphthalene or a naphthyl group; a hydrophobic monomer; a hydrophilic monomer; a crosslinker; an ultraviolet light absorbing material comprising vinyl anthracene or derivatives thereof; and a monomeric dye selected from the group consisting of disperse red 1 methacrylate, disperse red 13 methacrylate, disperse red 1 acrylate, disperse red 13 acrylate.

2. The composition of claim 1, wherein the ultraviolet light absorbing material further comprises material selected from the group consisting of beta-(4-benzotriazolyl-3-hydroxyphenoxymethyl) acrylate, 4-(2-acryloxyethoxy)-2-hydroxybenzophenone, 4-methacryloxy-2-hydroxybenzophenone, 2-(2'-methacryloxy-5'-methylphenyl)benzotriazole, 2-(2'-hydroxy-5'-methacryloxy-ethylphenyl)-2H-benzotriazole, 2-[3"-tert-Butyl-2'-hydroxy-5'-(3"-methacryloyloxypropyl)phenyl]-5-chlorobenzotriazole, 2-(3'-tert-Butyl-5'-(3-dimethylvinylsilylpropoxy)-2'-hydroxyphenyl)-5-methoxybenzotriazole, 2-(3'-Allyl-2'-hydroxy-5'-methylphenyl)benzotriazole, 2-[3'-tert-Butyl-2'-hydroxy-5'-(3"-methacryloyl-oxypropoxy)phenyl]-5-methoxybenzotriazole and 2-[3'-tert-Butyl-2'-hydroxy-5'-(3"-methacryloyloxypropoxy)phenyl]-5-chlorobenzotriazole.

3. A composition of claim 1, wherein the monomeric dye absorbs light in the 400-700 nm region.

4. A composition of claim 1, wherein the hydrophilic monomer(s) is selected from the group consisting of 2-hydroxy-ethylacrylate, 2-hydroxyethylmethacrylate, acrylamide, N-ornithine acrylamide, N-(2-hydroxypropyl)acrylamide, polyethyleneglycol acrylates, polyethyleneglycol methacrylates, N-vinyl, pyrrolidone, N-phenylacrylamide, dimethylaminopropyl methacrylamide, acrylic acid, benzyl methacrylamide, 4-hydroxybutylmethacrylate, glycerol mono methacrylate, glycerol mono acrylate, 2-sulfoethylmethacrylate, phenoxyethyl acrylate, phenoxyethyl meth-

acrylate, 2-(2-ethoxyethoxyl)ethyl acrylate, 2-(2-ethoxyethoxy)ethyl methacrylate, furfuryl acrylate, furfuryl methacrylate, and methylthioethylacrylamide.

5. A composition of claim 1, wherein the hydrophobic monomer(s) is selected from the group consisting of Lauryl 5 methacrylate, lauryl acrylate, 2-ethylhexyl acrylate, 2-ethylhexyl methacrylate, n-decyl acrylate, n-decyl methacrylate, hexyl acrylate, hexyl methacrylate, stearyl acrylate, stearyl methacrylate, isodecyl acrylate, isodecyl methacrylate, isobornyl acrylate, isobornyl methacrylate, vinyl laurate, 10 vinyl stearate, 1-hexadecyl acrylate, 1-hexadecyl methacrylate, n-myristyl acrylate, n-myristyl methacrylate, n-dodecyl methacrylamide, butyl acrylate, n-butyl methacrylate, isooctyl acrylate, isotridecyl acrylate, isooctyl methacrylate, and isotridecyl methacrylate. 15

* * * * *